

Work Order ID 96376-2

Monday, January 28, 2013 10:03:17 AM

96376

Page 1

Item ID: D3393-041

Revision ID:

Item Name: Battery Lock Assembly

Start Date: 1/25/2013 Start Qty: 4.00

Required Date: 1/28/2013 Req'd Qty: 4.00

Reference: rework to alike

Approvals: Process Plan:

QC:

Date: 13-1-28

Date:

Tooling:

SPC (Y/N):

N9000040100

Setup Start

NS1

Stop

NS2

Cust Item ID:

Customer:

Run Start

NR1

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D3393

Rev A

170

170

Small Fab

Small Fab

0.00

Memo

0.00

PULL FROM STOCK D3393-041 X 4 B95606

ASSEMBLE TO KEYED ALIKE

180

180

QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

SP
B-128

190

190

Large Fab

Large Fab

0.00

Memo

0.00

1/16 SS rod 316
M121603

①4 φ FF 13-01-28

①4

①4

13-01-29

JBL

Work Order ID 96376

Monday, January 28, 2013 10:03:17 AM

96376

Page 2

Item ID: D3393-041

Revision ID:

Item Name: Battery Lock Assembly

Start Date: 1/25/2013 Start Qty: 4.00

Required Date: 1/28/2013 Req'd Qty: 4.00

Reference: rework to alike

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan:

QC:

Date:

Date:

Tooling:

SPC (Y/N):

Date:

Date:

Run Start *NR1*

Stop *NR2*

Sequence ID/
Work Center ID

200

200

QC

Quality Control

Operation
Description

QC9- Inspect visual per QSI004- Fusion Welds

Memo

Set Up/
Run Hours

0.00

0.00

Tool ID Tool # Plan Code Accept Qty Reject Qty Reject Number Insp. Stamp

13-01-29

13-01-29

13-01-29

210

210

Packaging

Packaging

Identify as per dwg & Stock Location: 81493 0.00

Memo

0.00

1X

13-5-30

220

220

QC

Quality Control

QC21- Final Inspection - Work Order Release 0.00

Memo

0.00

13/5/31

MF 13-5-30

Picklist Print

Monday, January 28, 2013 10:03:16 AM

Page 1

Work Order ID: 96376
 Parent Item: D3393-041
 Parent Item Name: Battery Lock Assembly

Start Date: 1/25/2013
 Start Qty: 4.00

Required Date: 1/28/2013
 Required Qty: 4.00

Comments: IPP Rev:A New Issue 05-11-22 JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|------------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------------|---------------|----------------|--------|
| D3393-041 Battery Lock Assembly | | Manufactured | No | | | | Each | 0.0000 | | 95606 ⁴ | | | |
| D3393-13 Battery Lock Casing | | Manufactured | No | | | | Each | 3.0000 | | 4 | | 13/01/28 | |

if necessary

mk

13-1-28

Location

ST492

87143

095725

Loc Qty

3

3

Loc Code

3

15

D3393-3

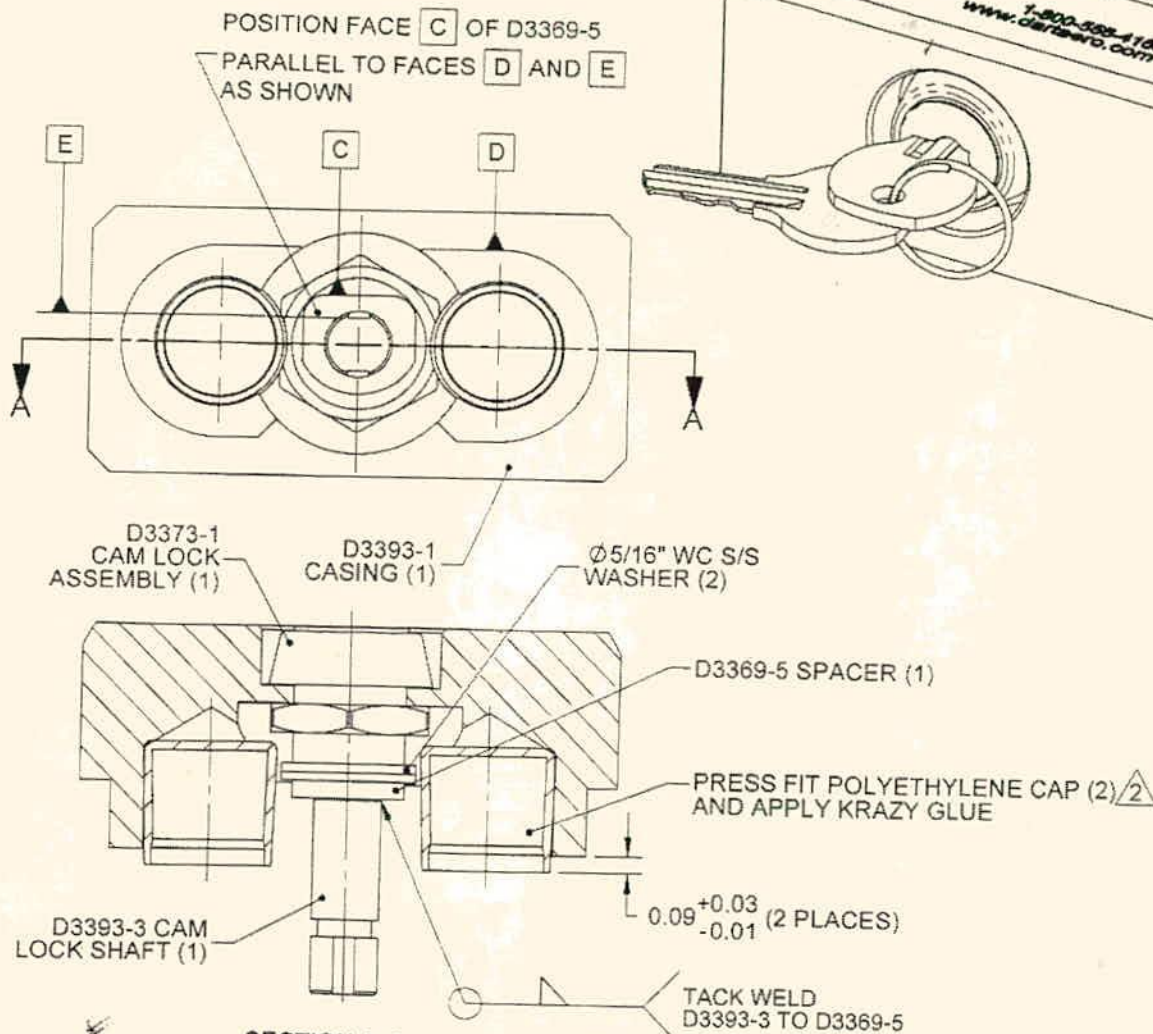
B 95971

for 1

Sh 1301/28

DART

| | | | |
|-------------------------|----------------|--|--------------|
| DESIGN 13 | DRAWN BY 13 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED TF | APPROVED AK | DRAWING NO. D3393 | REV. A |
| DATE 05.02.08 | | TITLE BATTERY LOCK | SHEET 1 OF 3 |
| A | 05.02.08 | NEW ISSUE | SCALE 1:1 |

RELEASED
12.5/03/09D2728-7
LABEL (1)**BATTERY LOCK SHOWN
LOCKED WITH KEY****D3393-041 BATTERY LOCK ASSEMBLY****NOTES:**

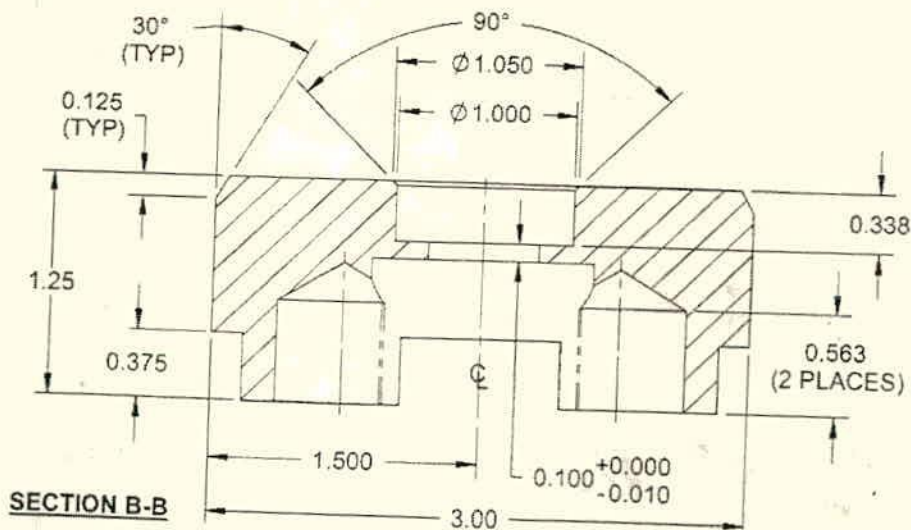
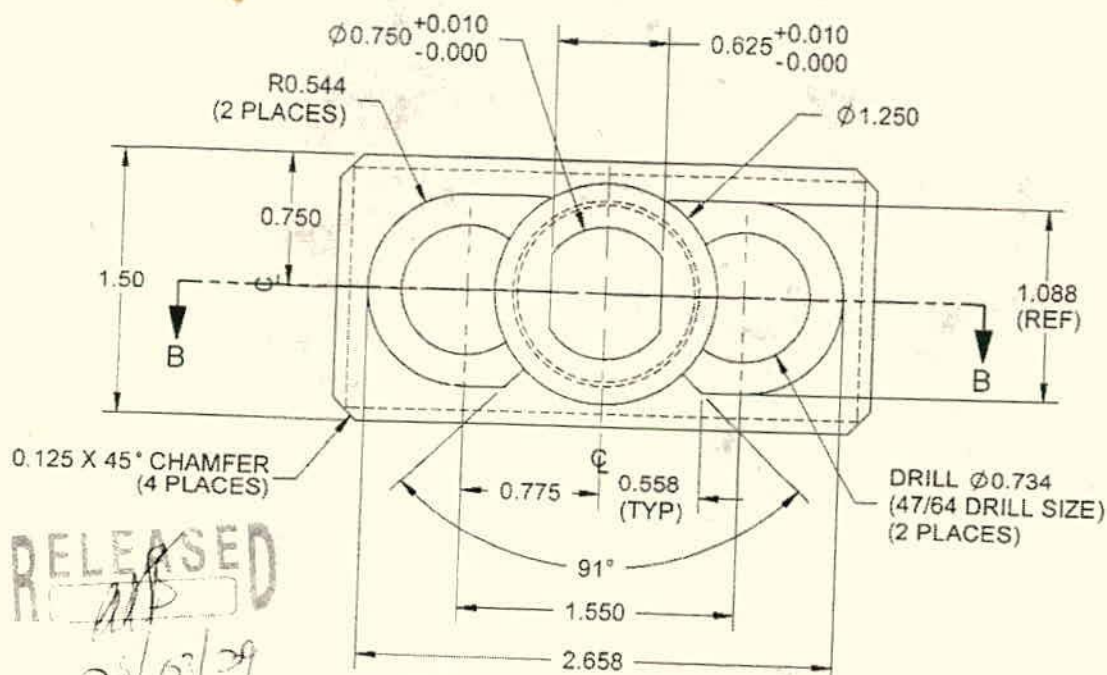
- 1) WELD PER DART QSI 004
- 2) POSSIBLE SUPPLIER: McMASTER-CARR, P/N 9567K21

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|-------------------------|------------------------------|--|--------|
| DESIGN 13 | DRAWN BY 13 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED 13 | APPROVED 13 | DRAWING NO. D3393 | REV. A |
| DATE 05.02.09 | TITLE BATTERY LOCK | SHEET 2 OF 3 | |
| | | SCALE 1:1 | |

**D3393-1 CASING****NOTES:**

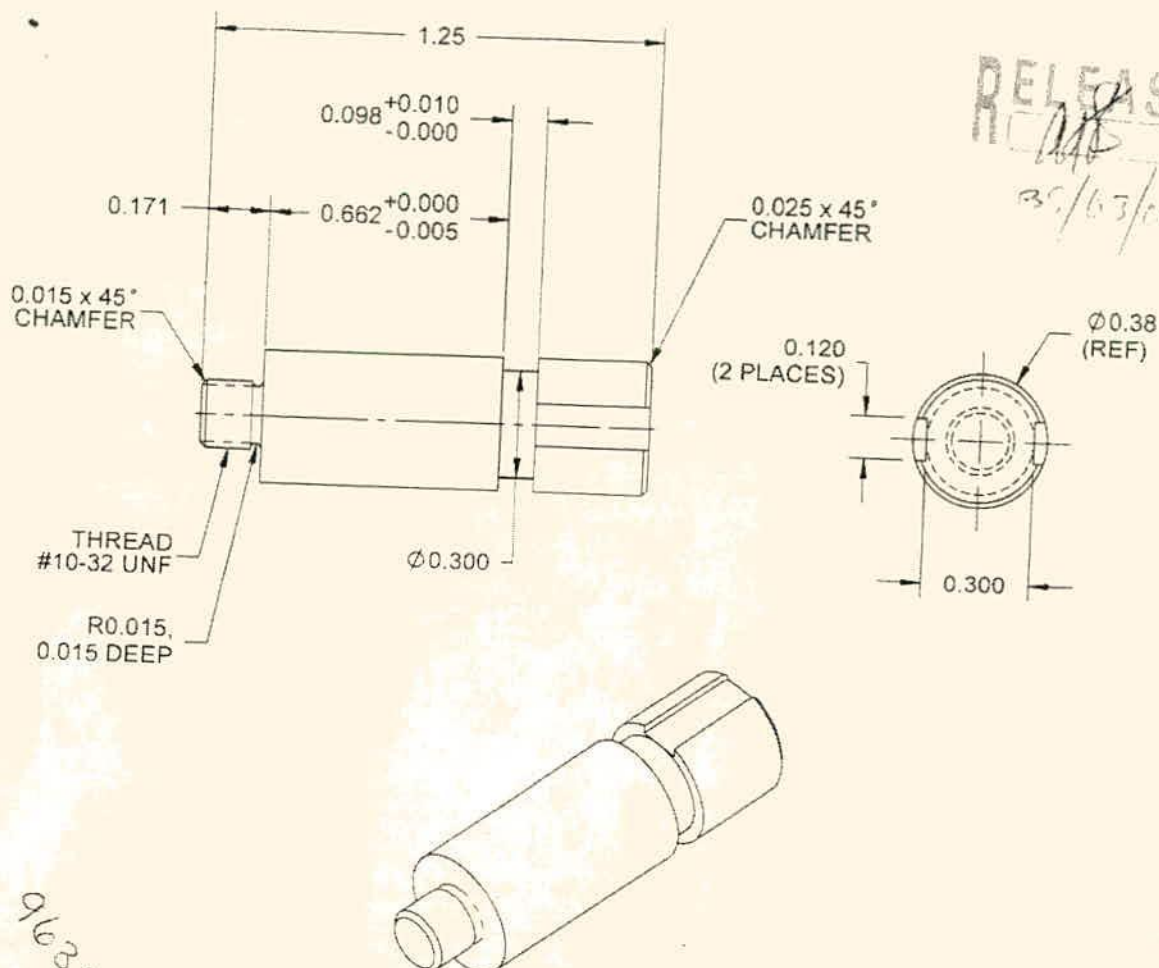
- 1) MATERIAL: 6061-T6/T651 (QQ-A-200/8 OR QQ-A-225/8)
(REF. DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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| | | | |
|------------------|-------------------------|--|--------------|
| DESIGN 13 | DRAWN BY 13 | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED 7F | APPROVED [Signature] | DRAWING NO. D3393 | REV. A |
| DATE 05.02.09 | | TITLE BATTERY LOCK | SHEET 3 OF 3 |
| | | | SCALE 2:1 |

**D3393-3 CAM LOCK SHAFT****NOTES:**

- 1) MATERIAL: AISI 303 S.S. (REF. DART SPEC. M303R0.375)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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